

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013098**Date Inspected:** 02-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG # TRIAL ASSEMBLY YARD

Segment: LIFT 7 East

This QA inspector performed Magnetic Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

OBE7-001~005, OBE7B-001~005

Nondestructive testing (NDT) notification No. 005459

This QA Inspector randomly observed the following work in progress:

Segment# 7BE-7CE

During in process visual inspection of 7BE-7CE Transverse Splice Welds , This QA Inspector observed ZPMC Quality Control (QC) personnel performing Magnetic Particle testing (MT) ZPMC Technician identified as Mr.Fu Zhi Qiang, for more comprehensive information refer the attached Photo.

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Segment # 7AE

This QA Inspector observed ZPMC personnel at Segment 7AE, FL3 Location between PP 45 and PP 49 bolts snug tightening is in progress. See the attached the below Photo.

Segment # 7BE-7CE

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE7-008; The Critical Welding Repair Report (CWRR) was B-CWR1363. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. See the attached below Photo.

Segment # 7BE-7CE

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 054467 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE7-008; The Critical Welding Repair Report (CWRR) was B-CWR1363. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials

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for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer